Date

Monday, 10/30/2006 4:14:58 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 29226 : 10313

P.O. Number

A14:

This Issue

: 10/30/2006

S.O. No. :NA

: NC Prsht Rev. First Issue

NA : 29038

Type

Est Rev:F

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D2648 REV D : N/A

: WEARPAD

: D26483

: D

Project Number **Drawing Revision**

:NIA Material

: 11/24/2006 **Due Date**

Qty: 200 Um:

Each

Written By

Previous Run

Checked & Approved By Comment

Re-format; Incorporated D2648-1 : Est: E 02.09.18

Now on Waterjet 06-08-14

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M1010S16GA

1010/1025/A21/6aA SHEET

Comment: Qty.:

0.0788 sf(s)/Unit

Total:

15.7500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA) Batch: **M9131**

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

************CUT WITH FILE D2648-1

Prog Rev: 0

08 12 14

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SEGOND CHECK



07.01.02



Comment: SECOND CHECK



5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary



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W/O:		WORK ORDER CHANGES							
DATE	STEP	EP PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		·							
	-								
			-						

Part No:	PAR #:	Fault Category: _	 NCR: Yes No	DQA:	Date: Of/C	plot
			QA: N/C	closed:	Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	,	Verification	Approval	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
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NOTE: Date & initial all entries

Monday, 10/30/2006 4:14:58 PM Date: User: Kim Johnston **Process Sheet Drawing Name: WEARPAD** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29226 Part Number: D26483 Job Number: Sea. #: Machine Or Operation: Description: NC BRAKE BRAKE NC 6.0 Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description 07 0124 MO03030 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL WELDING INSPECTION QC9 8.0 Comment: VISUAL WELDING INSPECTION 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING 10.0 m 10/60/ Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL &ONVERSION 11.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 13.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Page 2

Form: rprocess

Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHAN	GES				· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date Qty		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cateç	gory:	NCR	: Yes N	lo DQ /	\ :	_ Date: _	
						QA: N/0	Closed	d:	_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	n of NC Corrective Action		Section B		Verification		Approval	Approval
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NOTE: Date & initial all entries

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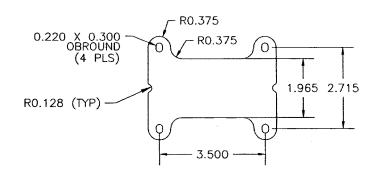
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NOTE: Date & initial all entries

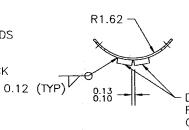
DART AEROSPACE LTD	Work Order:	29226
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	х	First Article	e	Protot	уре		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		mments
1.965	+/-0.010	10969	J		verN		
2.715	+/-0.010	2713	J		VRYN		
3.500	+/-0.010	3.497	J		VerN		
0.220 x 0.300	+/-0.010 x +/-0.010	D.231X0.302	1		VerN		
R0.375	+/-0.010	RO.375	J		Radius G	diver	
R0.128	+/-0.010	RO-128	V		RAdius	JUASI	
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Measured by:	M.M	Audited by:			Prototype	Approval:	N/A
Date:	PB 12 14	Date:	6751	02		Date:	N/A
Rev Date	Change					Revised by,	Approv <i>e</i> d
A 06.10.16					ŀ	KJ/JLM A	- Cull

D2648-1 FLAT PATTERN



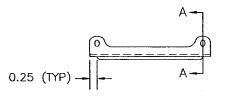
SECTION A-A R1.62 -7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK



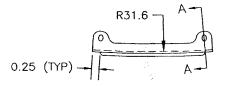
SECTION B-B

D2941-300 REMOVE POWDER COAT FROM THESE **SURFACES**

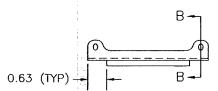
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







SHEET 1 OF

SCALE

99.11.17 ADDED D2648-7 97.06.26 97,05.30

В

99.11.17

R31.6 WAS R19.6 ENLARGE OBROUND, 0.375 WAS 0.250

97.03.25 NEW ISSUE DART RF DRAWING NO.

DART AEROSPACE USA, INC

D2648 TITLE WEARPAD

BREAK ALL SHARP CORNERS 0.063 MAX

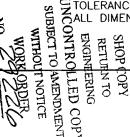
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (00063 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005

UTOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED COLUMN TOLERANCES ARE IN INCHES

ON THE RESERVE OF THE PER DART QSI 018

ON THE PER DART Q



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